

S P T

Work Order ID 146207 - /

May 11, 2016 12:39:15 PM



146207



Page 1

Item ID: D3695-3

Accept

Revision ID:

N900040100

Setup Start *NS1*

Item Name: Stopper

Stop *NS2*

Start Date: 5/20/2016 Start Qty: 10.00

10

Required Date: 6/10/2016 Req'd Qty: 10.00

10

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan: SH

Date: 01605 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3695

Rev E

100

100

BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.25 " long

DAS

44

9-89

16-05-17

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA733 Rev: C & Dwg D3695 Rev: E
2-Deburr per dwg D3695
3-TAP FOR 3/8"-24 HELICOIL

DAS

44

9-89

16-05-18

16/05/20

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

DAS

44

9-89

16-05-18

DQA:

Date: 16.08.09



QA Closed:

Date: 16-08-08

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 146207-1		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. D3695-3		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. 16-5951		Scrap ☐		Machining ☒		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☒		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date: 16/05/30		Step #: 110		QTY Effective: 3				MRB (QSI042) Approval DAS 9 9-89			
Description Work Order Deviation				Disposition							
1 part, the thread was off axis. 2 part the holes was off by .004" over tolerance.				test fit Test fit successful. DAS 12 9-89 16/7/17				Completed By 38 9-89 JUN 07 2016 Lead hand / Supervisor Approval Verification DAS 14 9-89 16/05/30 QC / QA Coordinator Approval DAS 38 9-89 JUN 07 2016			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☒ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER: ☐											

Work Order ID 146207

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146207

Page 3

Item ID: D3695-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stopper

Stop

NS2

Start Date: 5/20/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

(3)

DAS
38

JUN 07 2016

170

Identify as per dwg & Stock Location: 5t006

0.00

170

Packaging

Memo

0.00

Packaging

POSITIVE RECALL

EFFECTIVE 20/5/2016 AUTH SAD

RELEASED 42 DATE 16/7/17

DAS
6
9-89

JUN 09 2016

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

16/02/08

MCS JUN 09 2016

Picklist Print

May 11, 2016 12:39:19 PM

Page 1

Work Order ID: 146207

146207

Parent Item: D3695-3

D3695-3

Parent Item Name: Stopper

Start Date: 5/20/2016

Required Date: 6/10/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM IPP rev:B
10.11.29 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased		No		100	f	2.4030	0.37	3.894737			
										DAS			
										44			
										9.89		16-05-17	

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

Location	Loc Qty	Loc Code
MAT004	2.403	
m132772	0.3827	
m133265	0.6263	
m134158	1.394	

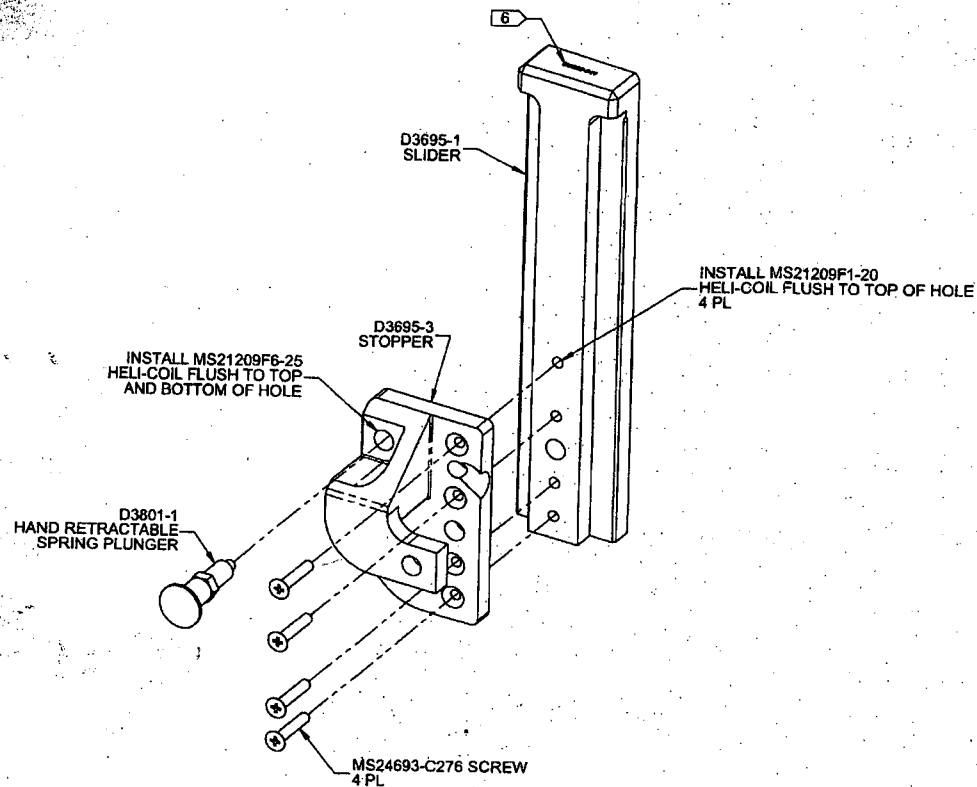
M134776

1.394'

2.58'

20160511

SA146207

**D3695-041 SLIDER ASSEMBLY****D3695-041 NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENT P/N "D3695-041" PER QSI 044 6.1
- 7) WEIGHT: D3695-041 = 0.63 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3695-041	SLIDER ASSEMBLY
1	1	D3695-1	SLIDER
2	1	D3695-3	STOPPER
3	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
4	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
5	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
6	4	MS24693-C276	SCREW

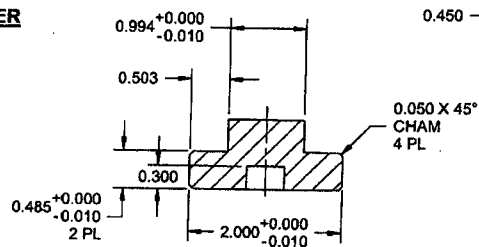
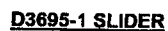
RELEASED
2012-07-16

E	ADDED R0.83 (ZN C8-3). REASON: PAR12-177.	MB	12.06.27
D	NOTE 6 UPDATED PER QSI. DIM 0.894 WAS 1.000 & 0.893 WAS 0.500 (ZN C8-2). REF NCR 10-324. CHAMFER ADDED TO D3695-1 (ZN C5-2).	JPH	10.08.24
C	UPDATED BOM TO CURRENT STANDARDS: REVISED ITEM 12 (ZN D3-1): DIMS 1.83 AND 1.075 WERE 1.81 AND 1.063. REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.27		

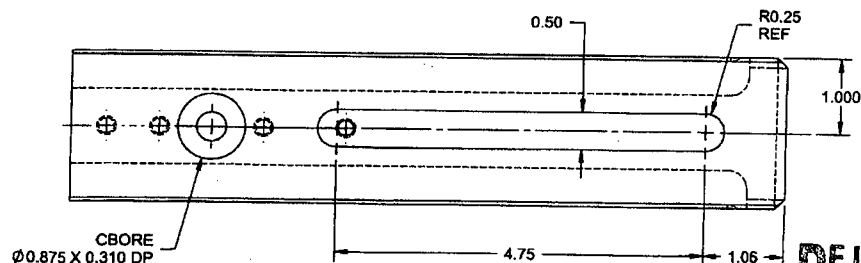
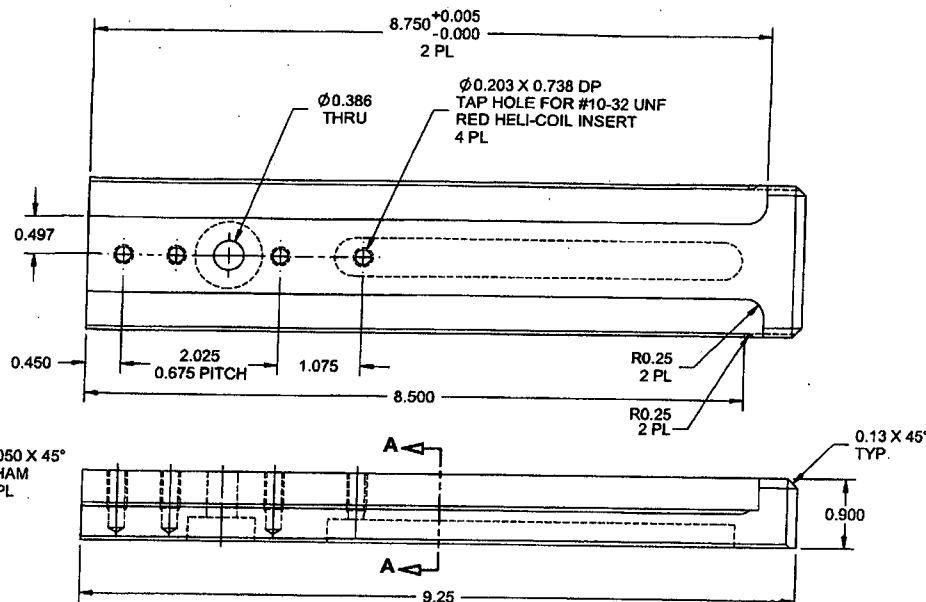
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3695** REV. E
TITLE **SLIDER ASSEMBLY** SCALE NTS
SHEET 1 OF 3

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SECTION A-A



D3685-1 NOTES:

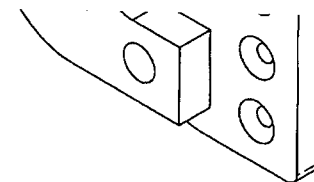
- D3695-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T-6510/T-6511/T-62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.43lbs

RELEASE
2012-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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MARC

HOLES ARE
0.015" OUT



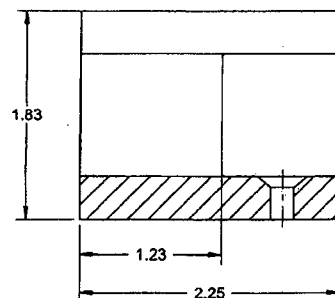
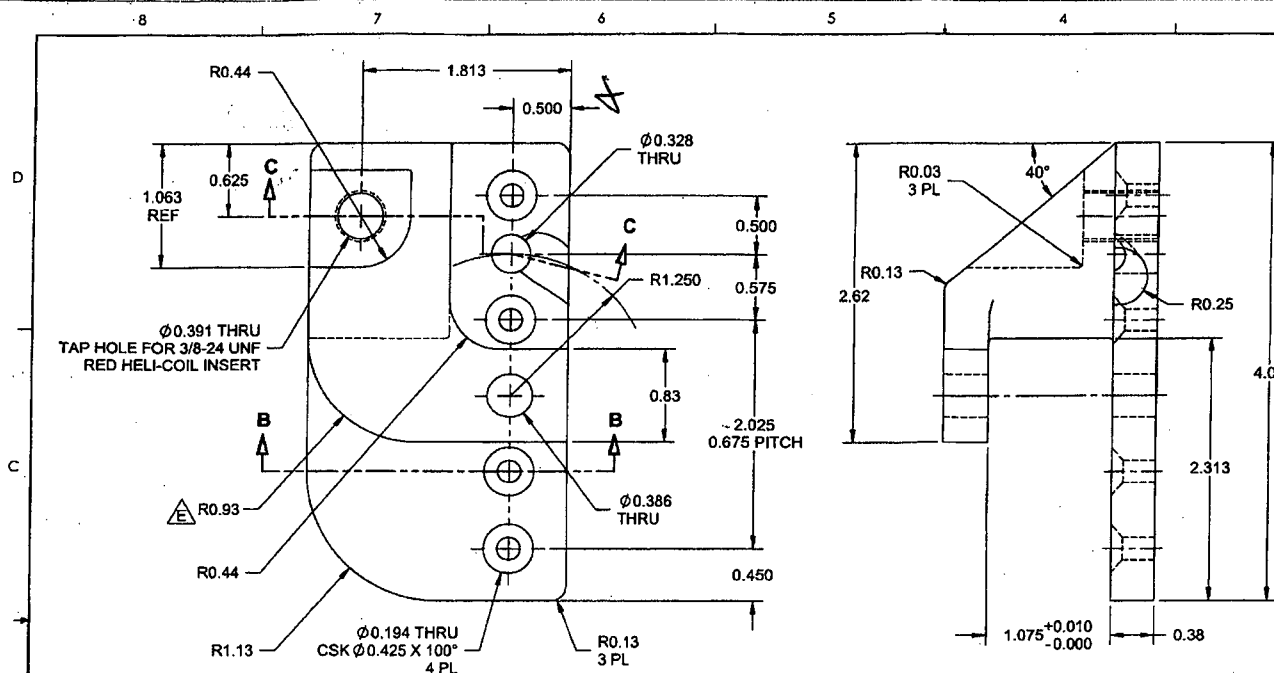
D3695-3 STOPPER

RELEASED
2012-07-16

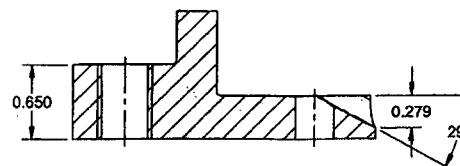
D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3695	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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SECTION B-B



SECTION C-C

DART AEROSPACE LTD		Work Order:	146207
Description: Slider		Part Number:	D3695-3
Inspection Dwg: D3695 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	.625	/		Vern	FK-04
1.063	+/-0.010	1.061	/		H-G.	31006.
Ø0.391	+0.006/-0.001	.391	/		Vern	FK-04
Ø0.194	+0.005/-0.001	.194	/		"	"
Ø0.425 x 100°	+/-0.010 x 0.5°	.425 x 100°	/		"	"
Ø0.386	+0.006/-0.001	.387	/		"	"
0.450	+/-0.010	.451	/		"	"
2.025	+/-0.010	2.025	/		"	"
0.83	+/-0.010	.830	/		"	"
0.575	+/-0.010	.575	/		"	"
0.500	+/-0.010	.500	/		"	"
Ø0.328	+0.006/-0.001	.328	/		"	"
0.500	+/-0.010	.506	/		"	"
1.813	+/-0.010	1.821	/		"	"
2.62	+/-0.030	2.616	/		H-G.	31006.
1.075	+0.010/-0.000	1.079	/		Vern	FK-04
0.38	+/-0.030	.370	/		"	"
2.313	+/-0.010	2.312	/		"	"
4.00	+/-0.030	4.001	/		"	"
1.83	+/-0.030	1.836	/		"	"
1.23	+/-0.030	1.216	/		"	"
2.25	+/-0.030	2.250	/		"	"
0.650	+/-0.010	.653	/		"	"
0.279	+/-0.010	.279	/		"	"

Measured by: DAS 44 9-89		Audited by: DAS 14 9-89		Preliminary Approval:	
Date: 16-05-18		Date: 16/05/30		Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	13.06.27	Dwg Rev updated	KJ	